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D3650-5

Job Sheet 184680



Part No: D3650-5

Job Qty: 5 ea

Part Name: Fwd Panel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 10/31/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-09-27 DD verified by: EC IPP Rev:B ECN 1113P 08-01-22 DD IPP
Rev:C ecn1162 08-04-02 DD verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	5 pcs		10/31/18	0.00	1.05	Waterjet 1		SC 18/11/18
110	QC	5 pcs		10/31/18	0.00	0.00	QC2 Waterjet-2		SC 18/10/18
120	QC	5 pcs		10/31/18	0.00	0.00	QC8-3		JAN 08 2019 68
130	Brake NC	5 pcs		10/31/18	0.00	3.11	Brake NC 1		DAS 9-89
140	QC	5 pcs		10/31/18	0.00	0.00	QC5		38 DAS
150	Small Fab	5 pcs		10/31/18	0.00	6.42	Small Fab-4		9-89 38 DAS
160	QC	5 pcs		10/31/18	0.00	0.00	QC5		FEB 26 2019 9-89
170	Packaging	5 pcs		10/31/18	0.00	0.00	Packaging3-1	STARTS	9-89
180	QC21-SA	5 Ea		10/31/18	0.00	0.00	QC21		FEB 28 2019

Part Op 100 - 1-Cut as per Dwg D3650 Dwg Rev: E Prog Rev: E 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Form as per Dwg D3650

140 - QC5- Inspect part completeness to step on W/O

150 - Assemble as per dwg D3650

160 - QC5- Inspect part completeness to step on W/O

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

DAS
21
9-89
FEB 28 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S26GA	304/318 0.018 Sheet	4.0650 sf (.813 ea)	100-Waterjet	FM17720
D3650-7	Seal	5 Ea (1 ea)	150-Small Fab	6161207
D3650-9	Angle	5 Ea (1 ea)	150-Small Fab	B132224
D3893-1	Doubler	5 Ea (1 ea)	150-Small Fab	F 96812
MS20427M3-3	Rivet	40 Ea (8 ea)	150-Small Fab	S148663
MS21060-3K	Nut Plate	10 Ea (2 ea)	150-Small Fab	FM132256-0
MS21062-3K	Nut Plate	10 Ea (2 ea)	150-Small Fab	FM132325
NAS9307/M-4-03	Rivet	60 Ea (12 ea)	150-Small Fab	F124561

4x =
NAS1149CN432R

12ea

F105940



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Container No: S122069



Part: D3650-5

Job No: 184680

Serial No/Batch: S122069

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/28/18

Plex 10/16/18 7:48 AM dart.lacelle.linda

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M304S26GA	4	40	0
150-Small Fab	D3650-7	5	12	0
	D3650-9	5	4	0
	D3893-1	5	8	0
	MS20427M3-3	40	384	0
	MS21060-3K	10	113	0
	MS21062-3K	10	139	0
	NAS9307/M-4-03	60	403	0
Part Specifications				
Specifications could not be found.				

Entered: TR Date: Oct 24/19.



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7540

Route update only ☐

Job: <u>184680</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS			
Part No. <u>D3650-5</u>		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☒ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☒ Water Jet ☐ Supplier Quality ☐

Date: 2019-07-15 Sequence #: _____ QTY Affected: 4 MRB (QSI042) 12 9/19/2019

Description Work Order Deviation	Disposition	Completed By
On drawing D3650-C-1 DEO we recommended to use NAS9307M-4-03 or CR3223-4-03 Rivet to replace MS20615-4M5 Rivet on D3650 Rev.C When we released D3650 Rev.D we didn't incorporate D3650-C-1 DEO	Acceptable to use NAS9307M-4 or CR3223-4 Rivet	53 9-89 19/07/22 Lead hand / Supervisor 30 9-89 JUL 22 2019 55 9-89 JUL 22 2019 OC / QA Coordinator

Root Cause	FAULT CATEGORY			
Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
Other/Details:				